

Date: Wednesday, 14/01/2009 8:34:53 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : X-BOLT SPACER
<b>Job Number</b> : 44631	
<b>Estimate Number</b> : 12321	
<b>P.O. Number</b> :	<b>Part Number</b> : D34901
<b>This Issue</b> : 14/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3490 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43013	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/01/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.01.14</u>	
<b>Comment</b> : Est Rev:A New Issue 06-03-03 JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0500W049

6061-T6 RD Tube .500 x.049W



**Comment:** Qty.: 0.2793 f(s)/Unit Total : 5.5860 f(s)

6061-T6 Tube .500 x.049W

(M6061T6T0.500W.049)

Batch: M108250

*09/01/15*

*20 pcs*

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



**Comment:** HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA628 &amp; DWG D3490

FOLIO REV: AADWG REV: A

2-DEBURR AS REQUIRED

*09/01/15*

*20 pcs*

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*09/01/15*

*20 pcs*

4.0

QC8

SECOND CHECK



**Comment:** SECOND CHECK

*09.01.15*

*20*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: LG

*09-01-15*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 14/01/2009 8:34:53 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 44631

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/16 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

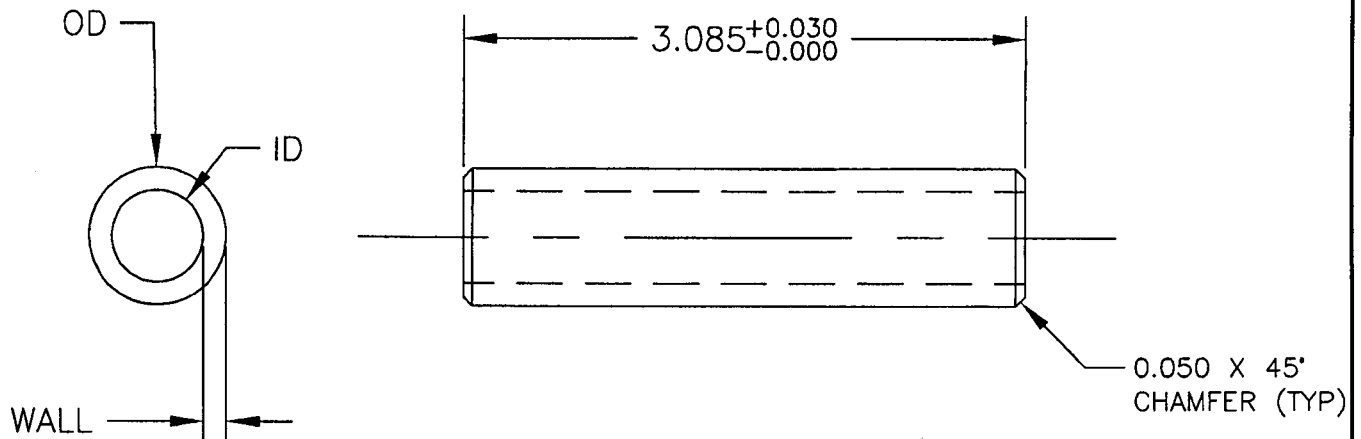
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER SCALE NTS	
A	06.01.04	NEW ISSUE	



**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

**D3490-1/-3/-5 CROSS BOLT SPACER**

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *44631*

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